Claims

1. A method for making a catalytic converter comprising:

wrapping a catalytic converter core in an intumescent mat;

surrounding said catalytic converter core and said intumescent mat with a pre-wound metal jacket;

compressing said pre-would jacket around said catalytic converter core and intumescent mat with tension bands; and

knocking said jacket at a frequency of 20 to 80 Hz during said compression to cause setting of said intumescent mat between said core and said jacket.

2. A method as specified in claim 1, wherein said knocking is at a frequency of 40 to 50 Hz.

3. A method as specified in claim 1, wherein said knocking takes place for a period exceeding 2 seconds.

4. A method as specified in claim 3, wherein said knocking takes place for a period of about 4 to 5 seconds.

5. A method as specified in claim 1, wherein said intumescent mat has an overlap and wherein said pre-wound metal jacket has an overlap, and wherein in said surrounding said overlap of said jacket is offset from said overlap of said mat by approximately 180°.

6. A method as specified in claim 1, wherein said compression by said tension bands is increased during said knocking.

7. A method as specified in claim 6, wherein said tension is increased to a value of 10 to 30 kN.

8. A method as specified in claim 7, wherein said tension is increased to 20 kN.

9. A method as specified in claim 1, wherein said housing jacket is tacked by spot welding after said compressing.

10. A method as specified in claim 9, wherein cores are welded to the ends of said tack welded housing by circumferential seams, and wherein said housing jacket is welded with a longitudinal seam following welding of said cones.

11. A catalytic converter made by the method of claim 1.

12. A catalytic converter made by the method of claim 5.

13. A catalytic converter made by the method of claim 10.